0.00

Memo

110

Quality Control

QC

									DQA:	Date:	
NCR: Yes	s / No				WORK ORDER NON-C	ONFORM	MANCE / UP		QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No NCR No	•				Rework Scrap Use-as-is Work Order Update		Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	l.	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	l .	or Non-conformance	Chief Eng		ription	Date	Verification	QC Inspector
Doc/Data											•
Equip/Tooling											
Operator							:				
Material											
Setup				·							
Other											
Process]										
Supplier									ļ		

FAULT CATEGORY Landing Gear General Bend Bending Grain Ovalized Pressure/Forced BOM/Route Centre Not Concentric to O/S Over/Under tolerance Hardware Temperature/Cure Broken/Damaged Cracks Inspection Incomplete Part Incorrect Weld Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Other Power Loss/Surge Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Wave/Twist in Tube Folio Outside Dimensions

Training Unapproved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

December-19-12	? 12:56:55 P.	M			,				·			
Item ID: Revision ID:	D3913-041			Accept	*N900	040	100)* S	etup Star	1 71	S1*	
Item Name:	Long Basket I	Base Assemby, 350							Stop	*N	S2*	
Start Date:	12/14/12	Start Qty: 1.00	*1*		Cust Item II	D:					٠	
Required Date:	1/11/13	Req'd Qty: 1.00	*1*		Customer:					•	•	
Reference:									σ.			
Approvals:	Process Pla	ın:	Date:	Tooling:	Da	ite:		R	un Star	171	R1*	
	QC:		Date:	_ SPC (Y/N):		nte:			Sto	*N	R2*	
Sequence ID/ Work Center II	D .	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
120		QC5- Inspect part compl	eteness to step on W/O	0.00	•						0AS 09	
120 QC Quality Control		Memo		0.00				13	PG·10-			
125 *125		Pressure Wash per QSI00	05 4.3	0.00				į	14	132	. 4	
HandFinish Hand Finishing		Memo		0.00				_/	_ M		_ ′	

NCR:	Yes	1	Nio
INC.IV.	15	,	1411

												DQA:	Dat	te:	
NCR: Y	es ,	/ No					WORK ORDER NON-C	COI	VFORI	MANCE / UPI	DATE			•	
			. "			_		-				QA Closed:	Dat	te:	
Nork Orde	er:						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		~
Part N	 lo						Rework Scrap Use-as-is		ı	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging		Engineering Quality Other
NCR N	lo	· · · · · · · · · · · · · · · · · · ·					Work Order Update			Large Fab	Composite]	Supplier		
Root					Desc	rip	otion of work order update	П	nitial	Act	tion	Sign &		\neg	
Cause	ļ	Date	Step	Qty			r Non-conformance		ief Eng		ription	Date	Verification	n	QC Inspector
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	c	entre No	t Concen	ntric to (o/s		BOM/Route		Hardwa	re _.		Over/Under	tolerance		Temperature/Cure
	C	racks					Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct		Weld
	c	rushed/C	crimped.				Burrs		Instruct	ions Incomplete/U	Jnclear	Part Lost/Mi	issing		Wrong Stock Pulled
	C	uffs					Contamination		Mainte	nance		Part Moved	•		•
[_]н	eat Treat	:				Countersink		Mislabe	l∈d		Positioned V	Vrong		
[Ir	spection	Strip in	Tube			Cut Too Short		Misread			Power Loss/	Surge		Other
	R	ipples in	Bend				Drill Holes		Offset		<u></u>	_	•		
		orque Wa	aves in E	xtrusio	1 [Drawing		Out of C	alibration					
	Ti	urning Se	auence		Γ		Finish		Out of S	eguence					

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

QC

Quality Control

Page 3 December-19-12 12:56:55 PM D3913-041 Item ID: Accept Setup Start *N900040100* Revision ID: Long Basket Base Assemby, 350 Item Name: 12/14/12 Start Otv: 1.00 Start Date: **Cust Item ID:** Rea'd Otv: 1.00 Required Date: 1/11/13 **Customer:** Reference: Process Plan: Date: **Tooling:** Date: Approvals: Stop SPC (Y/N): Date: Date: Reject Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Insp. Work Center ID Description Code **Qty** Qty Number Stamp **Run Hours** 130 White Gloss(Ref:4.3.5.2) per OSI005 4.3-Steel 0.00*120* 0.00 Powdercoat Memo 1- Plug holes and mask only interior of hinge (3) prior to powder Powder Coating 1 \$ St 13-211. START TIME: 9 OC3- Inspect Part Finish 0.00 140 *140*

0.00

Memo

										DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPDATE			
								<u> </u>		QA Closed	Date:	
Work Ord	er:					DISPOSITION			AGAINST	DEPARTMENT	/PROCESS	
Part l						Rework Scrap Use-as-is		ſ	Skid-tube Crosstube Machining Small Fab noforming Finishing	Pro	Water Jet od. Eng. Coor. re/Packaging	Engineering Quality Other
NCR	No.					Work Order Update	_		Large Fab Composite		Supplier	
Root					Desc	cription of work order update	T	Initial	Action	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description	Date	Verification	QC Inspector
oc/Data												
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rocess												
upplier	_											
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		L		L			FAUL	T CATE	GORY	1	· · · · · · · · · · · · · · · · · · ·	
Landi	ng (Gear				General						
		Bending			Γ	Bend		Grain		Ovalized	-	Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re	Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	ori Incomplete	Part Incorre	ct	Weld
		Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance	Part Moved		_
		Heat Trea	t			Countersink		Mislabe	led	Positioned '	Wrong	
		Inspection	n Strip in	Tube		Cut Too Short		Misreac	I	Power Loss,	/Surge	Other
		Ripples in	Bend			Drill Holes		Offset				
		Torque W	aves in E	xtrusio	n [Drawing		Out of C	Calibration			
		Turning Se	equence			Finish		Out of S	Sequence			

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 94582 Page 4 December-19-12 12:56:55 PM D3913-041 Accept *N900040100* Item ID: Setup Start **Revision ID:** Long Basket Base Assemby, 350 Item Name: Start Oty: 1.00 Start Date: 12/14/12 Cust Item ID: Required Date: 1/11/13 **Reg'd Oty:** 1.00 **Customer:** Reference: Run Process Plan: **Tooling:** Date: **Approvals:** Date: Stop SPC (Y/N): OC: Date: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Qty Qty Number Stamp **Work Center ID** Description Code **Run Hours** Assemble as per dwg 0.00 150 *150* 0.00 HandFinish Memo Hand Finishing Pick Kit QC5- Inspect part completeness to step on W/O 160 *160* 0.00 Memo **Quality Control**

170

Identify as per dwg & Stock Location: ()

124030-041/1294593 12 6 Plulodo0

0.00

0.00

Memo

Packaging Packaging

170

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-C	100	VFORI	MANCE / UP	DATE			
, .									· ,		QA Closed:	Date:	
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	No.					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	ı	Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data									:				
Equip/Tooling	Ш						a.						
Operator			:										
Material													
Setup									i				
Other ,													
Process													
Supplier													
Training													·
Unapproved													<u>.</u>
						F	AUL	T CATE	GORY				
Landi	ng G	iear				General		_			_		_
	Ш	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Ш	Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Ш	Cracks				Broken/Damaged		Inspect	on Incomplete		Part Incorre	ct	Weld
		Crushed/0	Crimped,			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		_
		Heat Trea	t			Countersink		Mislabe	led		Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 94582 Page 5 December-19-12 12:56:55 PM Accept Item ID: D3913-041 *N900040100* Setup Start **Revision ID:** Long Basket Base Assemby, 350 Item Name: Start Qty: 1.00 **Start Date:** 12/14/12 **Cust Item ID:** Req'd Qty: 1.00 Required Date: 1/11/13 **Customer:** Reference: Start Run Date: _____ Process Plan: **Tooling:** Date: Approvals: Stop Date: SPC (Y/N): Date: Sequence ID/ Tool ID Tool # Plan Reject Reject Operation Set Up/ Accept Insp. Qty Qty Number Stamp **Work Center ID** Description Code **Run Hours** 0.00 180 QC21- Final Inspection - Work Order Release *180*

0.00

Memo

QC

Quality Control

M-13-2-13

												DQA:	Date:	:
NCR:	Yes	/ No					WORK ORDER NON-C	100	VFOR	MANCE / UPE	DATE			
								1				QA Closed:	Date	:
Nork Ord	er:						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part							Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR	No.						Work Order Update]		Large Fab	Composite]	Supplier	_
Root					Des	crip	otion of work order update	Π	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		O	r Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
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Land	ing (7					General	_				-		. <u></u>
		Bending					Bend	<u> </u>	Grain			Ovalized	L	Pressure/Forced
	L	Centre No	ot Concer	ntric to (o/s		BOM/Route	L	Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks]		Broken/Damaged	_	Inspecti	ori Incomplete		Part Incorred	at	Weld
		Crushed/0	Crimped.		- [Burrs		Instruct	ions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	L	Cuffs			ļ		Contamination		Mainte	nance		Part Moved		
	L	Heat Trea	t				Countersink		Mislabe	led		Positioned V	Vrong	_
Ž		Inspection	n Strip in	Tube			Cut Too Short		Misread	I		Power Loss/	Surge	Other
		Ripples in	Bend				Drill Holes		Offset					
		Torque W	aves in E	xtrusion	۱ [Drawing		Out of 0	Calibration				
		Turning Se	equence				Finish		Out of S	equence		-		

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

December-19-12 12:56:53 PM

Page 1

Work Order ID:

94582

Parent Item:

D3913-041

Parent Item Name:

Long Basket Base Assemby, 350

Start Date: 12/14/12

Required Date: 1/11/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC

IPP Rev:B chg qty's DD 10.04.12

	verified by:EC	IPP RE	EV:C 12	2.07.24 AS PE	ER DWG REV.I	B DD VERF	EC						
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
N3-10A		Purchased	No			150	Each	170.0000	6	0 6	/ <u> </u>	<u> </u>	
Bolt									3	803	64=	4	
				Location		Loc Qty	<u>L</u>	oc Code					
				GA		49							
				122	800	49							
				ST512		121						n	
				122	2800	121			12.	2800		///	
N960JD8	NAS1149DN832J	Purchased	No			150	Each	0.0000	2	2.	r 49- 6		
Washer)3348	_JB_		
D2581		Manufactured	No			100	Each	86.0000	2	2	^ ~	1.	1
Mounting Bracket									3	36 <i>3</i> 63	7 2 2 1	بريد	113:01
				Location		Loc Qty	<u>L</u>	oc Code					
				WA004		86							
				707	766	2							
				812	253	1							
				825		2							
				832		3							
				854		2							
				863		37			<u> </u>				
				877		2						_	
				885		12			Character and Ch		1. /		
				928	3/1	25					42 CM	/	
D2931 / Sumper		Manufactured	No			150	Each	2,296.0000	2	2	-3B	13	-62-05
				Location		Loc Oty	<u>1</u>	oc Code			•		
				GA		298							
				460	064	298			46	1064			
				ST021		1998							
				864	135	1998							

												DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-C	100	VFOR	MANCE / UPDATE				
												QA Closed:	Date:	
Nork Ord	er:						DISPOSITION			AG	AINST DE	PARTMENT	PROCESS	
Part NCR							Rework Scrap Use-as-is Work Order Update			Machining Sm. noforming Fir	sstube all Fab nishing posite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root Cause		Date	Step	Qty	Desc		tion of work order update r Non-conformance	ı	nitial ief Eng	Action Description		Sign & Date	Verification	QC Inspector
oc/Data	Γ	Jule	Step	αι,		Ť	T TO TO COMO TIMA TO COMO TO C	-	ici ziig	Description		Date	Vermeation	QC IIISPECTOI
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Land	ng (Bending Centre No	. .		\(\begin{array}{c} \begin{array}{c} \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\	-	General Bend BOM/Route		Grain			Ovalized	F	Pressure/Forced
	\vdash	Cracks	or concer	itric to t)/3		Broken/Damaged	\vdash	Hardwa	on Incomplete	-	Over/Under Part Incorred		Temperature/Cure Weld
	┢	Crushed/0	Crimped		-	\neg	Burrs	H		ions Incomplete/Unclear	-	Part Lost/Mi		Wrong Stock Pulled
	\vdash	Cuffs				1	Contamination		Mainte			Part Moved		
		Heat Trea	t			-	Countersink		Mislabe		—	Positioned V	Vrong	
		Inspection	n Strip iņ	Tube			Cut Too Short		Misread	I		Power Loss/	Surge	Other
		Ripples in	Bend				Drill Holes		Offset			· 		
		Torque W	aves in E	xtrusior	· [Drawing		Out of 0	Calibration				
		Turning Se	equence		Ţ.		Finish		Out of S	Sequence				

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

December-19-12 12:56:54 PM

Work Order ID:	94582							
Parent Item:	D3913-041					Star	t Date: 12/14/12	Required Date: 1/11/13
Parent Item Name:	Long Basket Base Assemby, 350					Star	rt Qty: 1.00	Required Qty: 1.00
D3913-1 Rib	Manufactured	No		100	Each	4.0000	B 87	541 → 1x
			Location	Loc Qty		Loc Code		\$ 13.01.04
			WA005	4				3013/01/09
			87543	1				
			88463	3				? ;
D3913-15 Wide Handle Plate	Manufactured	No		100	Each	23.0000	B937	94 18 13.01.24
			Location	Loc Oty		Loc Code		
			WA004	23				
			90084	4				
			92699	3			***	
			93794	4				
			94153	2				
•			94154	2				• .
			94272	4				
			94317	4				
D3913-3 Rib	Manufactured	No		100	Each	9.0000	38844	3 St 13:01:24
			Location	Loc Qty		Loc Code		
			WA005	9				
			69160	1				
			84651	1				
			88443	7				•
D3913-7 Rib	Manufactured	No		100	Each	5.0000	B884	191 →1x SS 13:01:93
			Location	Loc Oty		Loc Code	BOOM	97-14
			WA005	5			200 /	385/4/->ly
			88491	5				D40171719
			30.7.	5				

NCR: Yes / No	WORK ORDER NON-	-CONFORMANCE / UPDATE
Work Order:	DISPOSITION	AGA

Rework

Use-as-is

Work Order Update

Description of work order update

or Non-conformance

General

Qty

Step

Scrap

			,
	DQA:	Date:	J
ATE	QA Closed:	Date:	
AGAINST DI	EPARTMENT,	/PROCESS	
Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
on otion	Sign & Date	Verification	QC Inspector
nclear	Ovalized Over/Under Part Incorred Part Lost/Mi	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled

_		 	 _	 _	
	Bending	Bend	Grain	Ovalized	Pressure/Forced
L	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged	Inspectior Incomplete	Part Incorrect	Weld
L	Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination	Maintenance	Part Moved	-
	Heat Treat	Countersink	Mislabeled	Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes	Offset	 •	
	Torque Waves in Extrusion	Drawing	Out of Calibration		
	Turning Sequence	Finish	Out of Sequence		
	Wave/Twist in Tube	Folio	Outside Dimensions		
ORMS/Quali	ty Assurance\approved QA/NCRWO Rev G				

FAULT CATEGORY

Skid-tube

Machining

Large Fab

Action

Description

Thermoforming

Initial

Chief Eng

Part No.

NCR No.

Landing Gear

Date

Root

Cause

Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved

H:/F

December-19-12 12:56:54 PM

Work Order ID:	94582							
Parent Item:	D3913-041					Start	Date: 12/14/12	Required Date: 1/11/13
Parent Item Name:	Long Basket Base Assemby, 350					Start	Qty: 1.00	Required Qty: 1.00
D3913-9 Hinge Rib	Manufactured	No		100	Each	7.0000	1 B945/	2 1/ 13.01.24
			Location	Loc Oty		Loc Code		
			WA005	7				
			70138	1				
			88136	3				
			88215	3				
D3916-041 Rib Assembly	Manufactured	No		100	Each	10.0000	B886	59-21 SS13.01.24
			Location	Loc Qty		Loc Code		
			WA005	10				
			81444	2			MAC TO MACHINE MACHINE	
			88659	4				
			92826	4				. 1
D3916-5 Light Rib	Manufactured	No		100	Each	17.0000	B9416	64 >3 St 130/24
			Location	Loc Qty		Loc Code		
			WA005	11			•	* * *·
			77142	1				
			82933	4				
			88665	6				
			WA006	6				
			89274	6				
D4016-1 Hinge Half, Base	Manufactured	No		100	Each	37.0000	3 B98	St 13.01.24
			Location	Loc Qty		Loc Code		l. l
			WA004	13				13.01.24
			88790	13				
			WA005	24				
			92636	6				
			93117	18				

											DQA:	Date	•		
NCR:	Yes	/ No			-	WORK ORDER NON-	COI	NFORM	ANCE / UP	DATE					
											QA Closed:	Date	:		
Work Ord	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part I	No.					Rework Scrap Use-as-is Work Order Update	Machining Small Fab Thermoforming Finishing			Crosstube Small Fab Finishing Composite	ı	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root					Descri	ption of work order update	Π	Initial	Act	ion	Sign &				
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descr	iption	Date	Verification	QC Inspector		
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved															
						F	AUL	T CATE	GORY						
Landi		Bending				General Bend		Grain		——	Ovalized		Pressure/Forced		
	-	Centre No Cracks	ot Concer	ntric to (BOM/Route Broken/Damaged		Hardwa Inspecti	re on Incomplete		Over/Under Part Incorre	<u></u>	Temperature/Cure Weld		
	_	Crushed/0	Crimped.	nped. Burrs				4	ions Incomplete/U	Jnclear	Part Lost/Mi	issing	Wrong Stock Pulled		
	-	Cuffs	Contamination					Mainte			Part Moved				
	—	Heat Trea		Countersink				Mislabe			Positioned V	_	_		
	Inspection Strip in Tube					Cut Too Short	_	Misread			Power Loss/	Surge	Other		
	Ripples in Bend Drill Holes				Drill Holes	1	Offset								

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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December-19-12			Shop	Packet Print	:-			Page 4
			94109	4			<u></u>	-
			89204	12				_
			88849	10				_
			8/330 88323	8				_
			WA004 87330	42 8				_
			<u>Location</u> WA004	Loc Oty		Loc Code		Sy 13.01.24
Handle Plate						L. C. I		1/
D4021-1	Manufactured	No		100	Each	42.0000	3 B882	33-3x.
			94071	1		40.000		-
			92776	9				-
			88260	6				_
			84972	1				- •
			81442	2				_
			WA007	19			27701	1 //
,			Location	Loc Qty		Loc Code	39407	,
End Mesh, Basket	ivianatactarea						B92=	276 - 1x II 13:01.
D4020-11	Manufactured	No		100	Each	19.0000	2	2 1
			90344	6			,	•
			88671	4				•
			70341 81445	2				
			WA005	13				
			Location	Loc Qty		Loc Code		SH 13.01.24
Rib							17.20	1 /
D4017-9	Manufactured	No		100	Each	13.0000	²	2 5 7 1 -> 2
			88392	9				
			85435	1				
			82969	1				
			69730	1				
			WA005	12				
			Location	Loc Qty		Loc Code		
Rib	Manufactured	110		700	Lucii	12.0000	B 88	392 Sy 13.01.24
D4017-7		No		100	Each	12.0000	•	1 2:1
Parent Item Name:	Long Basket Base Assemby, 350					Start	Qty: 1.00	Required Qty: 1.00
Parent Item:	D3913-041					Start 1	Date: 12/14/12	Required Date: 1/11/13
Work Order ID:	94582							

									DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-C	CONFOR	MANCE / UF		QA Closed:	Date:	
Work Order:					DISPOSITION		•	AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is Work Order Update	- 1	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	A	ction	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling		Ì								:	
Operator		-								1	
Material											

FAULT CATEGORY **Landing Gear** General Bending Bend Grain Ovalized Pressure/Forced Centre Not Concentric to O/S BOM/Route Over/Under tolerance Temperature/Cure Hardware Cracks Broken/Damaged Inspection Incomplete Weld Part Incorrect Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Other Power Loss/Surge Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Folio Wave/Twist in Tube Outside Dimensions

Setup Other Process Supplier Training Unapproved

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Work Order ID: 94582 Parent Item: D3913-041 Start Date: 12/14/12 Required Date: 1/11/13 Long Basket Base Assemby, 350 Start Oty: 1.00 Required Oty: 1.00 Parent Item Name: D4021-5 150 42,0000 Manufactured No Each 2 Blanking Plate Loc Qty Location Loc Code ST084 42 85065 2 88151 88151 14 89059 26 D4034-041 100 Each 4.0000 Manufactured No B94048 Sy 13.01.24 Aft Upper Rib Assembly Location Loc Otv Loc Code WA005 84048 3 92648 D4034-043 No 100 Each 5.0000 Manufactured Fwd Upper Rib Assembly Location Loc Otv Loc Code WA005 5 82980 2 3 89956 D4672-1 100 Each 10.0000 Manufactured Blanking Plate Location Loc Qty Loc Code WA005 10 88253 6 92497

4

										DQA:	Date	:			
NCR:	Yes	/ No				WORK ORDER NON-O	CONFO	RMANCE /	UPDATE						
	•			-						QA Closed:	Date				
Work Ord	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part I	_					Rework Scrap Use-as-is Work Order Update	The	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other			
Root	\neg				Descri	tion of work order update	Initial		Action	Sign &					
Cause						or Non-conformance	Chief Er	ig D	escription	Date	Verification	QC Inspector			
Doc/Data						-			1						
Equip/Tooling							-								
Operator															
Material															
Setup															
Other															
Process															
Supplier	Ш											1			
Training	Ш		:												
Unapproved	Ш														
						F.	AULT CA	TEGC/RY							
Landi	ng G	ear				General				_	_	_			
	Ц	Bending				Bend	Grain	1		Ovalized		Pressure/Forced			
	Щ	Centre No	t Concer	ntric to	0/s	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure			
	Ц	Cracks				Broken/Damaged	Inspe	ction Incomplet	e	Part Incorre	ct	Weld			
	Ц̈́	Crushed/C	Crimped.	•		Burrs	Instru	ictions Incomple	ete/Unclear	Part Lost/M	issing	Wrong Stock Pulled			
	Ц̈́	Cuffs				Contamination	Mair	itenance		Part Moved					
	Heat Treat					Countersink	Misla	beled		Positioned \	Vrong	_			
•	Inspection Strip in Tube					Cut Too Short	Misre	ad		Power Loss/	Surge	Other			
	Ripples in Bend					Drill Holes	Offse	t							
	∐¹	Torque W	aves in E	xtrusio	n	Drawing	Out of Calibration								
						Finish	Out	f Sequence							

Wave/Twist in Tube

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94582 Work Order ID: D3913-041 **Start Date: 12/14/12** Required Date: 1/11/13 Parent Item: Start Qty: 1.00 Required Qty: 1.00 Long Basket Base Assemby, 350 Parent Item Name: 100 33 33 M304EX0.75-16F No sf 978.4313 Purchased Expanded Metal Flat SS M124070 >33 Sy 13.01.29 Location Loc Qty Loc Code WA007 978.4312637 102.9036 117197 120917 50.88673 121521 0.00013372 122080 63.0699 122315 11.245 122534 160 122604 61.238 122884 36.5679 123448 288 123855 204.52 150 711.0000 MS20600-AD4W3 No Each Purchased Cherry Rivets Loc Qty Loc Code Location GA 72 122151 72 377 ST311 123525 377 WA003 262 107939 133 122452 129

											DQA:	Date:			
NCR:	′es	/ No				WORK ORDER NON-	COI	NFORI	MANCE / UPDA	ATE	·				
											QA Closed:	Date:			
Work Orde	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
						Rework	7	Skid-tube Crosstube				Water Jet	Engineering		
Part I	10.		· · · · · · · · · · · · · · · · · · ·			Scrap			Machining Small Fab			d. Eng. Coor.	Quality		
NCD.						Use-as-is	4	Therr	noforming	Finishing	Rec/Stor	e/Packaging	Other		
NCR I	VO.					Work Order Update	_}		Large Fab	Composite		Supplier	J LJ		
Root					Desci	cription of work order update	- 1	Initial	Actio	n	Sign &				
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descrip	tion	Date	Verification	QC Inspector		
oc/Data			l												
quip/Tooling			{												
perator															
/laterial															
etup															
ther															
rocess															
upplier															
raining															
Inapproved															
					· · · · · · · · · · · · · · · · · · ·		FAUL	T CATE	GORY		<u> </u>				
Landi	ng (1			_	General	_	,			•		_		
		Bending				Bend	_	Grain			Ovalized		Pressure/Forced		
		Centre No	ot Concer	ntric to	o/s	BOM/Route	<u>_</u>	Hardwa	re		Over/Under	tolerance	Temperature/Cure		
	Cracks					Broken/Damaged	<u> </u>	Inspect	ion Incomplete		Part Incorred	ct	Weld		
		Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/Und	clear	Part Lost/Mi	ssing	Wrong Stock Pulled		
		Cuffs				Contamination		Mainte	enance	<u> </u>	Part Moved				
	Heat Treat					Countersink		Mislabe	eled		Positioned V	Vrong	_		
	Inspection Strip in Tube					Cut Too Short		Misread	d		Power Loss/	Surge	Other		
	Ripples in Bend					Drill Holes		Offset							
		Torque W	aves in E	xtrusio	n \lceil	Drawing	Out of Calibration								
	Turning Sequence Finish							Out of	ut of Sequence						

Wave/Twist in Tube

December-19-12 12:56:55 PM

Work Order ID: Parent Item: Parent Item Name: MS21042L3 Nut

NAS1149F0332P

WASHER

94582

D3913-041

Long Basket Base Assemby, 350

Purchased

Purchased

No

Start Date: 12/14/12

Required Date: 1/11/13

Start Qty: 1.00

Required Qty: 1.00

No	150 Each	4,778.0000	6 6 J.B.
Location	Loc Oty	Loc Code	V :
FP001	143		·
122141	143		
GA	458		
122452	458		
ST314	677		
117885	32		
119017	55		
119075	138		
123265	452		
ST506	3500		
123900	3500		123900
No	150 Each	h 10,822.000	12 12 7 3 13-62-05

4,778.0000

Location	Loc Qty	Loc Code	
GA	202		
122063	202		5 × 122063
ST294	400		
122063	400		
ST295	220		
121259	20		
123352	200		
st510	10000		7×123352
123900	10000		

150

Each

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-O		NFORM	ANCE / UP	DATE			
											QA Closed:	Date:	
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	٠ ِ o.					Rework Skid-tube Machining Use-as-is Work Order Update Large Fab			Machining of orming of the second sec	Crosstube Small Fab Finishing Composite	Pro Rec/Sto	Engineering Quality Other	
Root					Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	1	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data										· · · · · · · · · · · · · · · · · · ·			
Equip/Tooling													
Operator													
Material													
Setup													
Other													
Process													
Supplier													
Training													
Unapproved													
		•				F	AUL	T CATE	GORY				
Landi	ng (ear				General		-		<u></u>	-		_
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	L	Inspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs					Contamination		Mainte	nance		Part Moved		
	Heat Treat					Countersink		Mislabe	led		Positioned Wrong		
		Inspection	n Strip in	Tube		Cut Too Short		Misread			Power Loss,	'Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

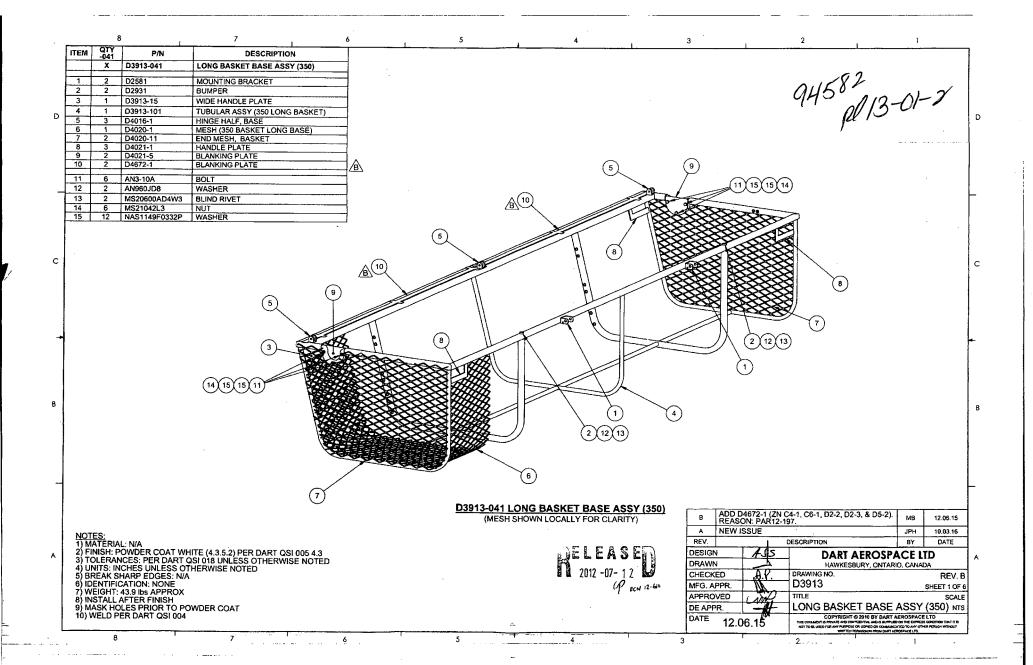
Torque Waves in Extrusion

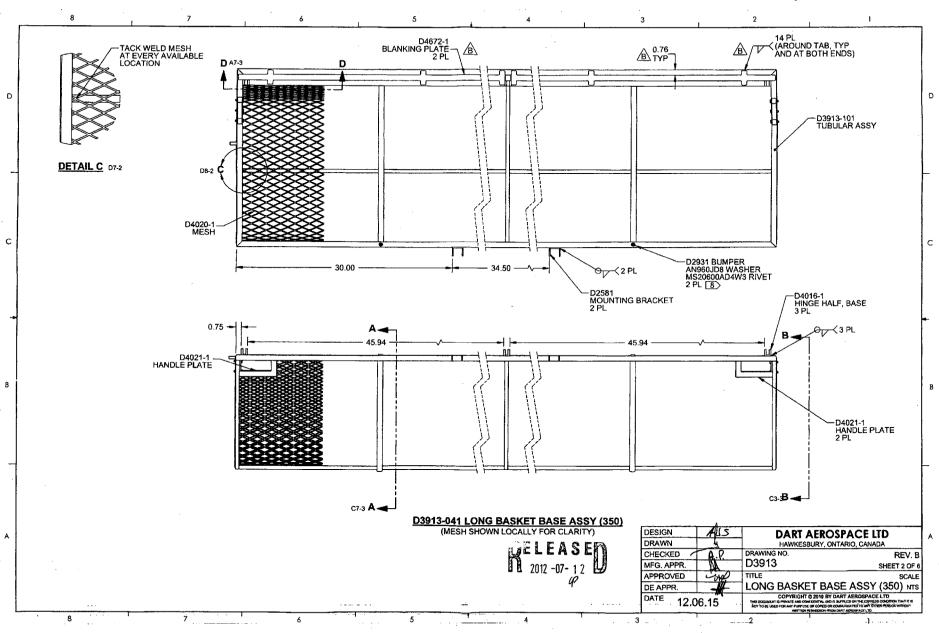
Drill Holes

Drawing

Finish

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